

Work Order ID 102613-2

June-04-13 10:30:12 AM

Ship Tomorrow

102613

SPLIT-2

Page 1

Item ID: D4545-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Inner, LH (Lower)

Start Date: 6/04/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 6/21/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *13-06-04*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4545	C								
100	Pick Kit	0.00				<i>15</i>			<i>SB 12/04/12</i>
100						<i>15</i>			
Packaging	Memo	0.00							
Packaging									
110		0.00							
110						<i>15</i>			<i>SB 13/03/12</i>
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AND BEND TABS AS PER DWG								
	2- DISASSEMBLE AND DEBURR								
	3- DIMPLE HOLES AS PER DWG								

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Page 2

Item ID: D4545-041
Revision ID:
Item Name: Retainer, Inner, LH (Lower)

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 6/04/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 6/21/13 Req'd Qty: 15.00

15

Customer:

Reference:

Run Start ***NR1***

Stop ***NR2***

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 23 138.29				15			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				15	15	138.29	
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				8x			13/09/03

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Item ID: D4545-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner, LH (Lower)

Start Date: 6/04/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 6/21/13 Req'd Qty: 15.00

15

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

145

Small Fab

Small Fab

Memo

INSTALL NUT PLATES AND ASSEMBLE AS PER DWG

0.00

0.00

8x

13-09-04/B

DAS
27
9-89

147

147

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

count tabs and record quantity
QTY: 20

0.00

0.00

8

13 9.3

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: ST531

Memo

0.00

0.00

8

13-09-04/B

Work Order ID 102613

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Page 4

June-04-13 10:30:12 AM

Item ID: D4545-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner, LH (Lower)

Start Date: 6/04/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 6/21/13 Req'd Qty: 15.00

15

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

13/9/6

13-0941

Picklist Print

June-04-13 10:30:15 AM

Page 1

Work Order ID: 102613

102613

Parent Item: D4545-041

D4545-041

Parent Item Name: Retainer, Inner, LH (Lower)

Start Date: 6/04/13

Required Date: 6/21/13

Start Qty: 15.00

Required Qty: 15.00

Comments:

IPP REV:A 12.01.13 new issue DD verf:JLM
12.02.27 AS PER DWG REV.B DD VERF:EC
as per dwg revC DD verf:EC

IPP REV:B
IPP REV:C 12.05.08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4541-1		Manufactured	No			100	Each	30.0000	1	15			
										**			
											SB 13/08/28		

D4541-1
Bracket

Location	Loc Qty	Loc Code
GA	30	M103175
78764	3	
90436	10	
91410	15	
91411	2	

D4542-1		Manufactured	No			100	Each	19.0000	1	15			
										**			
											SB 13/08/28		

D4542-1
Retainer, Inner, lh

Location	Loc Qty	Loc Code
GA	19	M102601
101313	15	
90649	2	
91446	2	

Picklist Print

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Work Order ID: 102613

Parent Item: D4545-041

Parent Item Name: Retainer, Inner, LH (Lower)

102613

D4545-041

Start Date: 6/04/13

Required Date: 6/21/13

Start Qty: 15.00

Required Qty: 15.00

MS20426AD3-4

Purchased

No

145

Each

24,644.00

40

600

MS20426AD3-4

RIVET

**

PS 13/09/03

Location

Loc Qty

Loc Code

ST333

12

123352

12

ST334

8000

123164

8000

ST505

8000

124814

8000

ST509

8632

124586

632

125578

8000

320

MS21059L3K

Purchased

No

145

Each

9,511.000

19

285

MS21059L3K

Nutplate

**

PS 13/09/03

Location

Loc Qty

Loc Code

ST316

150

124603

150

st507

4500

123603

1500

124586

3000

ST510a

3361

123346

361

124291

3000

ST511

1500

124093

1500

152

Picklist Print

June-04-13 10:30:15 AM

Page 3

Work Order ID: 102613

102613

Parent Item: D4545-041

D4545-041

Parent Item Name: Retainer, Inner, LH (Lower)

Start Date: 6/04/13

Required Date: 6/21/13

Start Qty: 15.00

Required Qty: 15.00

MS21061L3K

Purchased

No

145

Each

301.0000

1

15

MS21061L 3K

**

NUT PLATE

Handwritten: 6/13/08/03

Location

Loc Qty

Loc Code

ST316

132

124555

32

125268

100

ST317

169

123346

4

123355

60

123603

60

124093

45

Handwritten numbers on lines:
1
4
3

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5F	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21081L3K	NUTPLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: AFTER FORMING AND PRIOR TO ASSEMBLY, CHEMICAL CONVERSION COAT D4541-X & D4542-X PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

UNDER REVIEW

OK 12/13/11
OK 12/13/11

102613 MCL
13-06-04

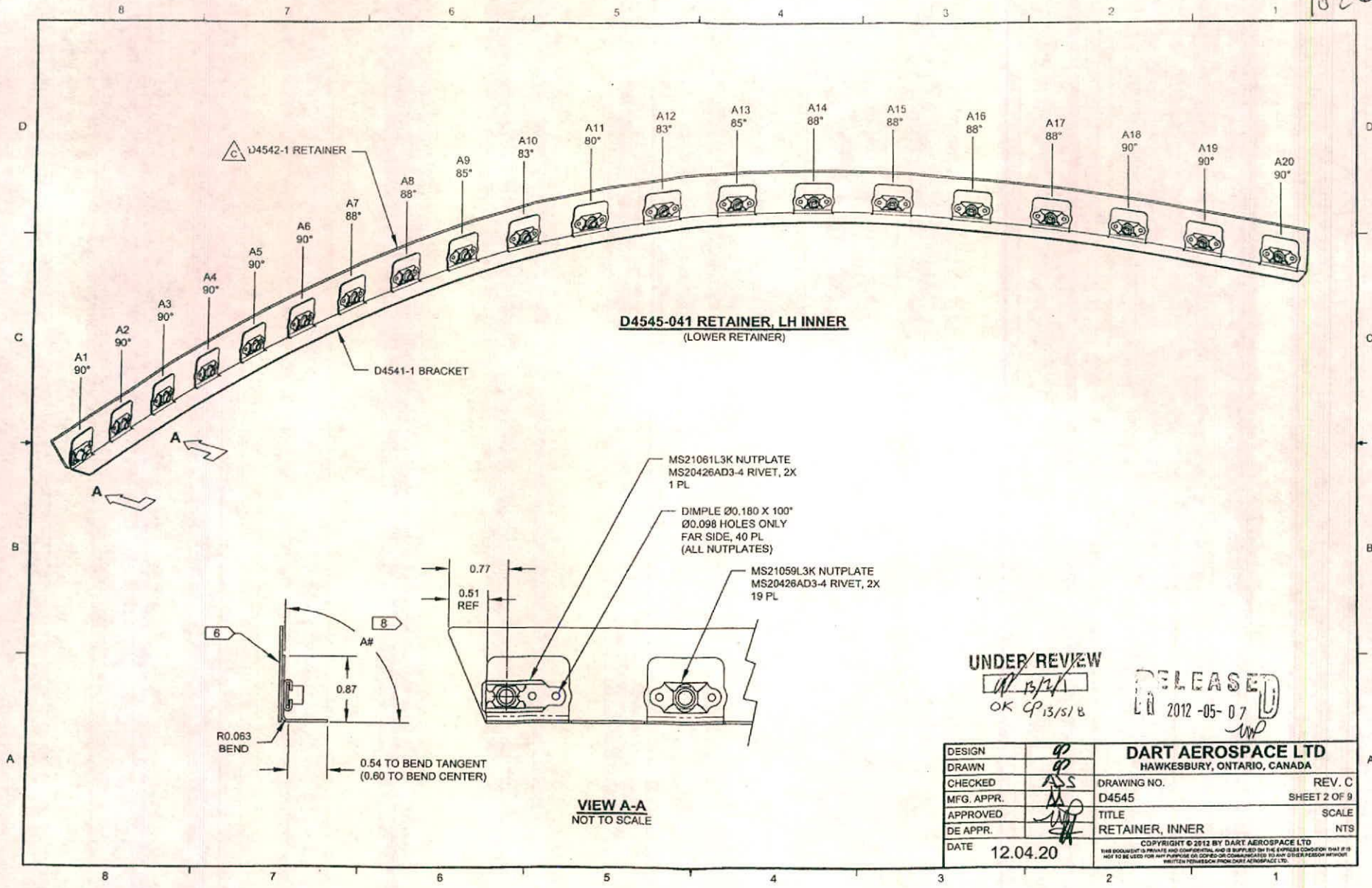
C	CHG FINISH (ZN A8-1); D4541-5F WAS -5 (C4-1) REMOVE TRANSFER DRILL NOTES	CP	12.04.20
B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD
HAWKESSBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D4545 SHEET 1 OF 9
TITLE SCALE
RETAINER, INNER NTS

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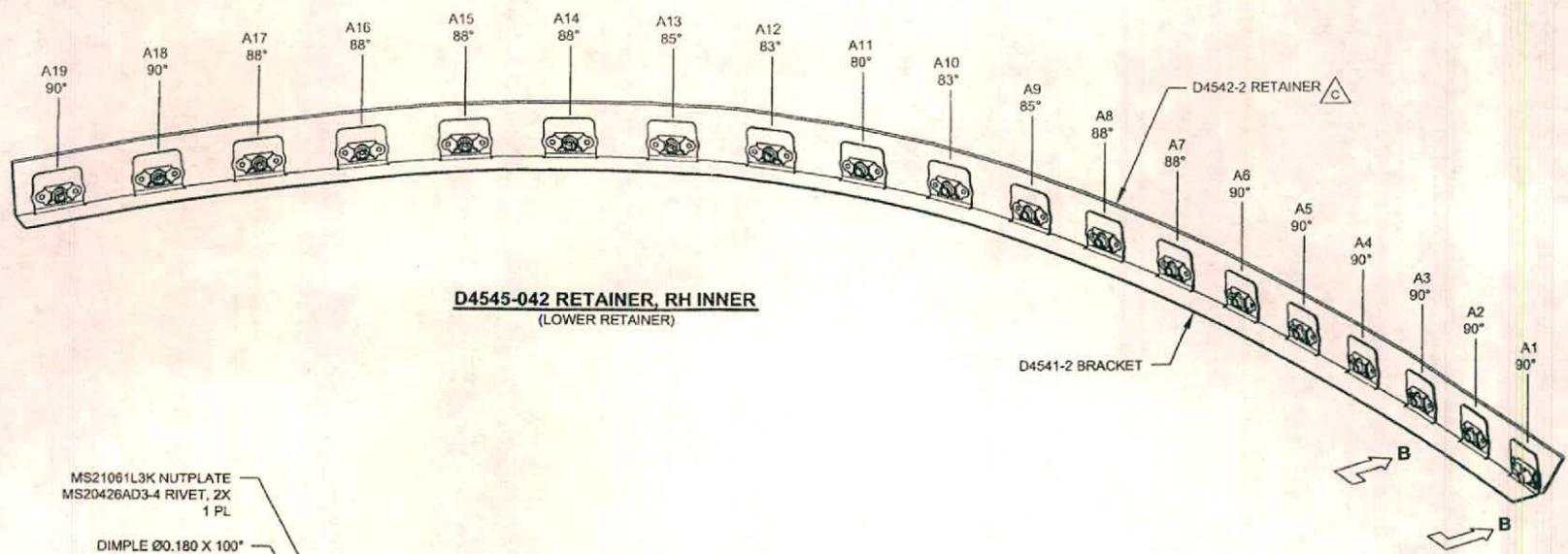


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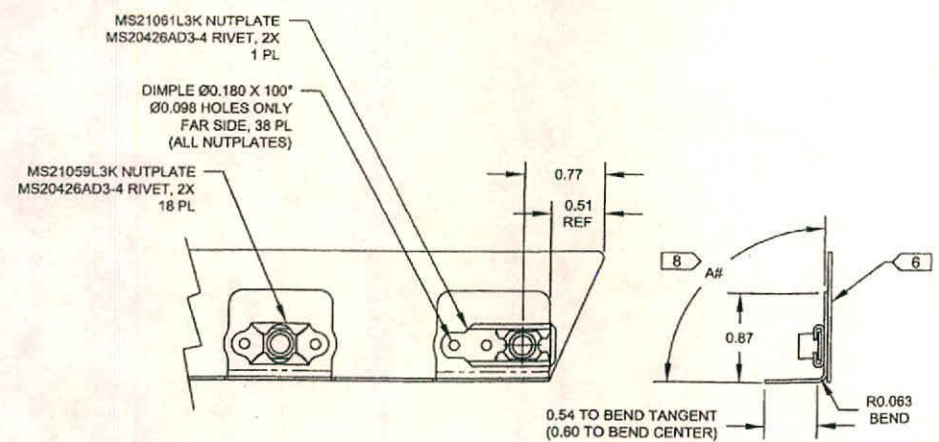
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2012-05-07

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D4545-042 RETAINER, RH INNER
(LOWER RETAINER)



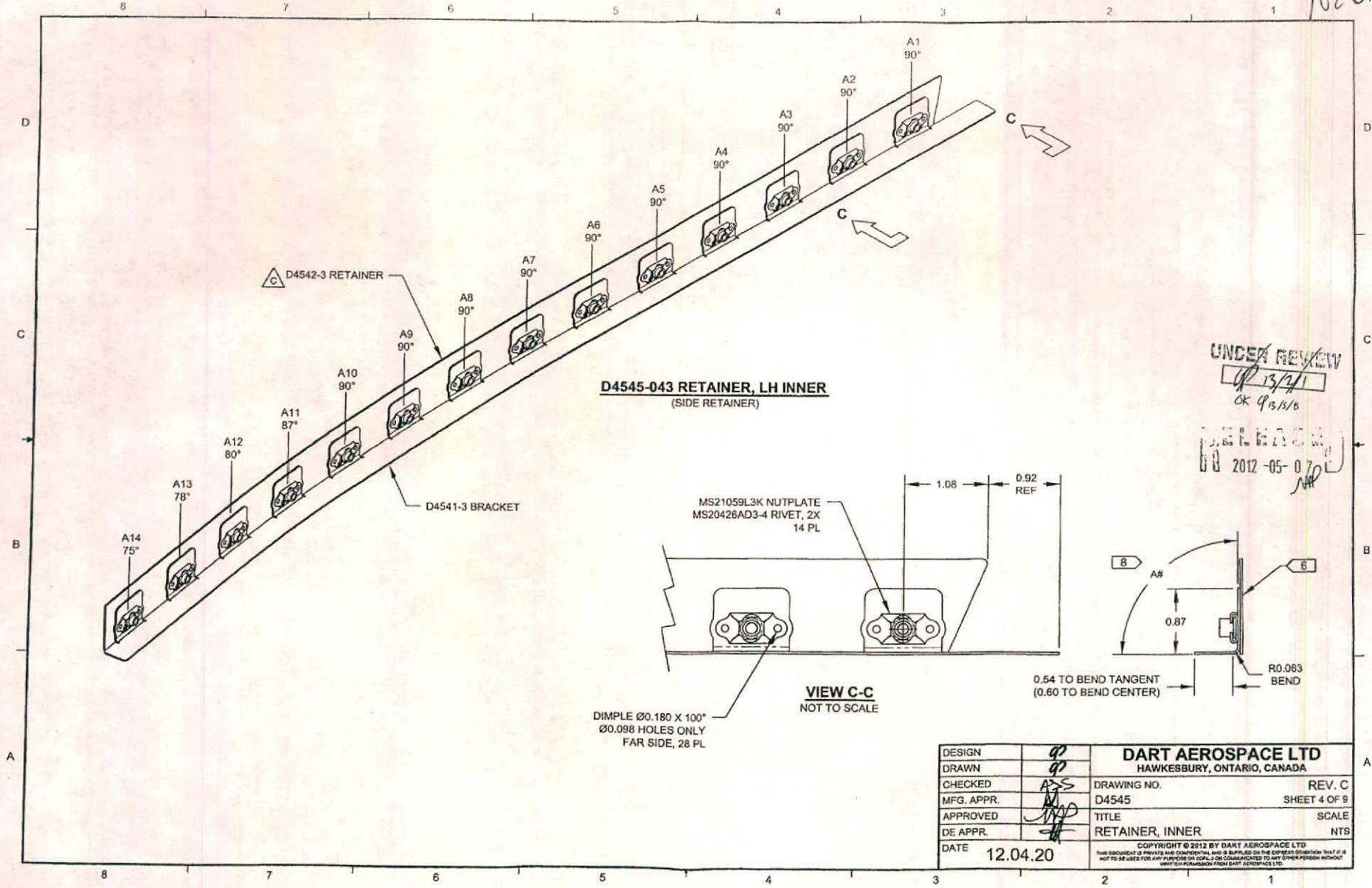
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NOT TO SCALE

UNDER REVIEW
13/1/12
OK 17/1/12

2012-05-07
JMP

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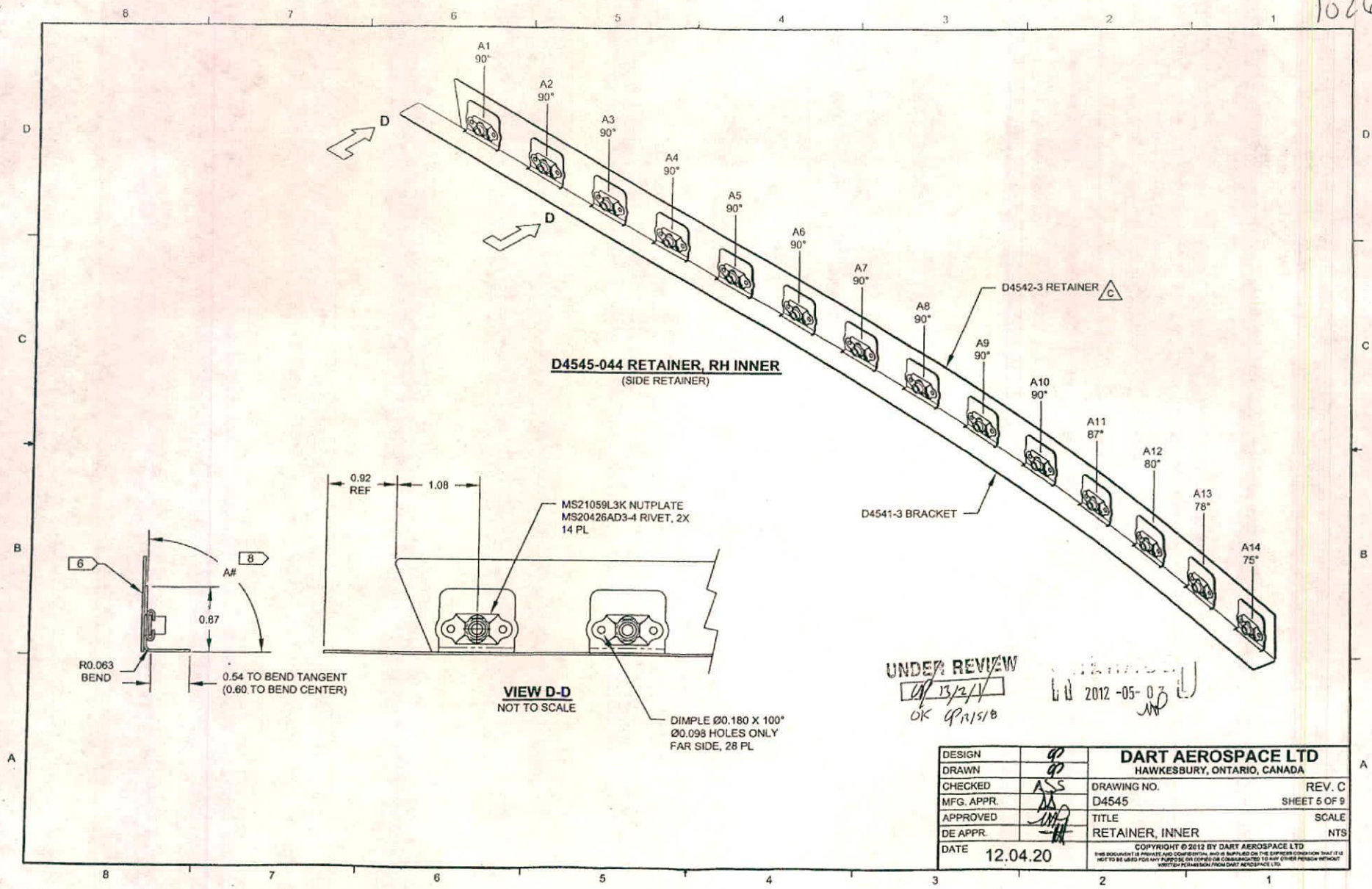
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13/9/11
OK 9/3/16

2012-05-07

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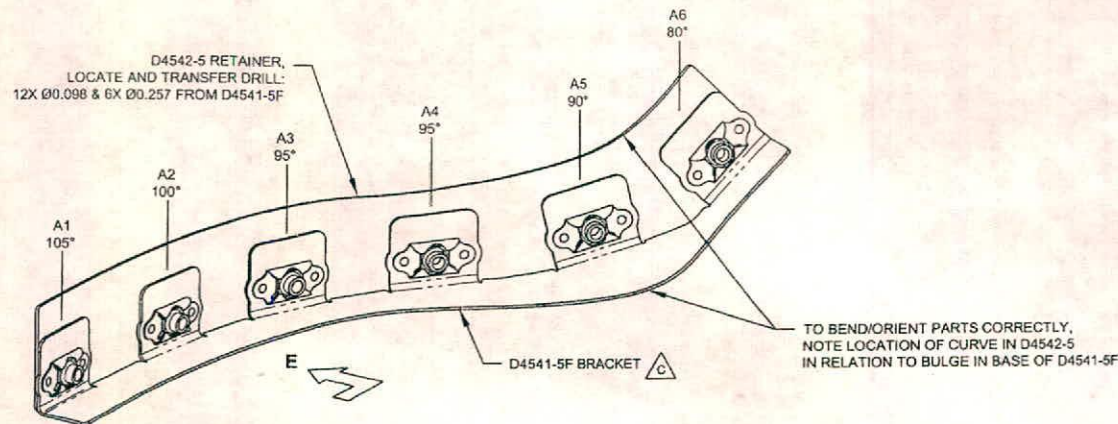


UNDER REVIEW
OK 13/2/11
OK 9/11/11

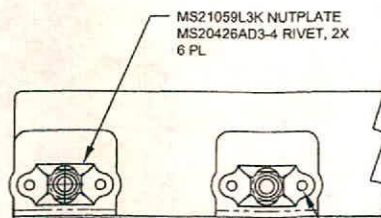
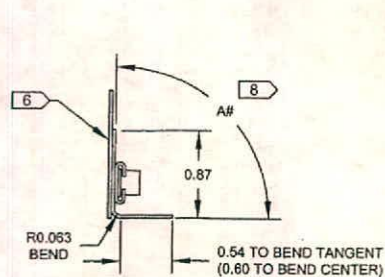
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D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



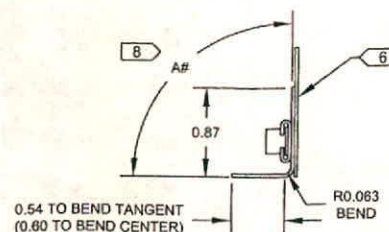
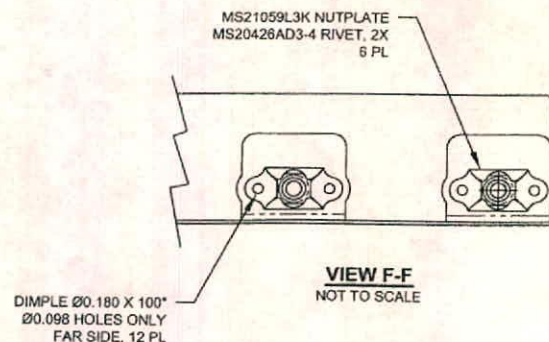
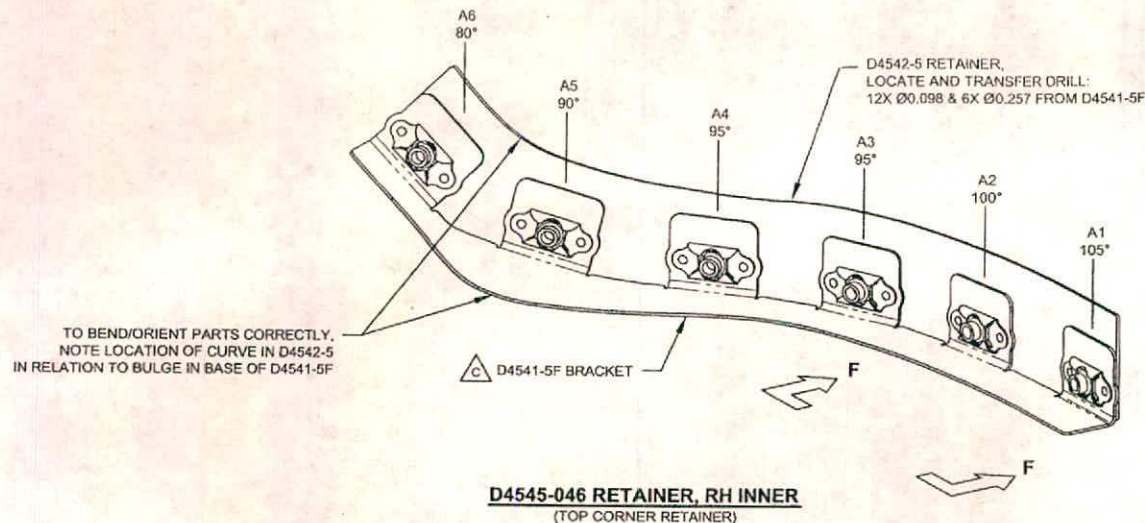
VIEW E-E
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UNDER REVIEW

13/2/1
OK 13/5/8

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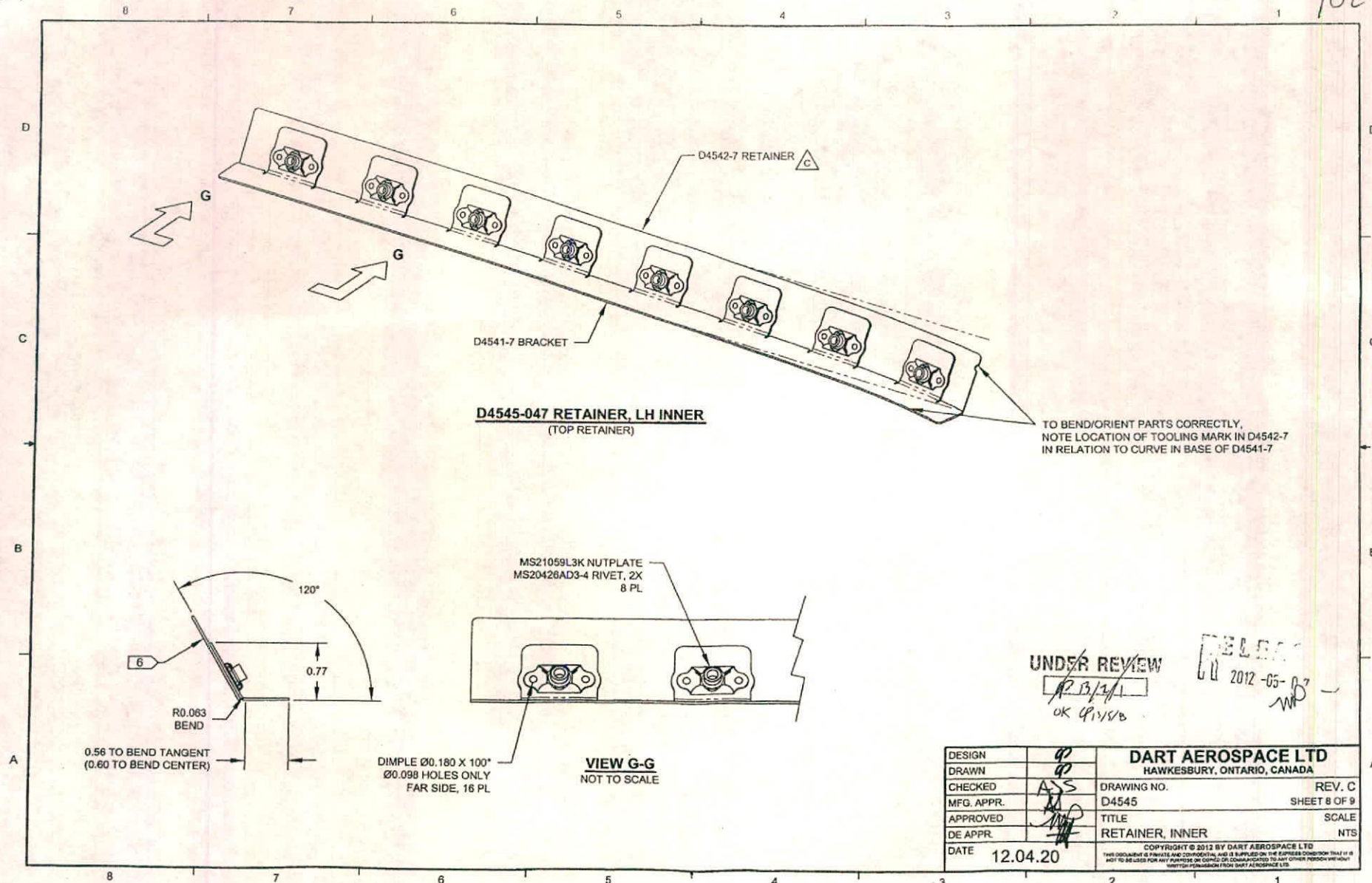


UNDER REVIEW
4/13/11
OK 4/13/11

RELEASE
2012-05-07

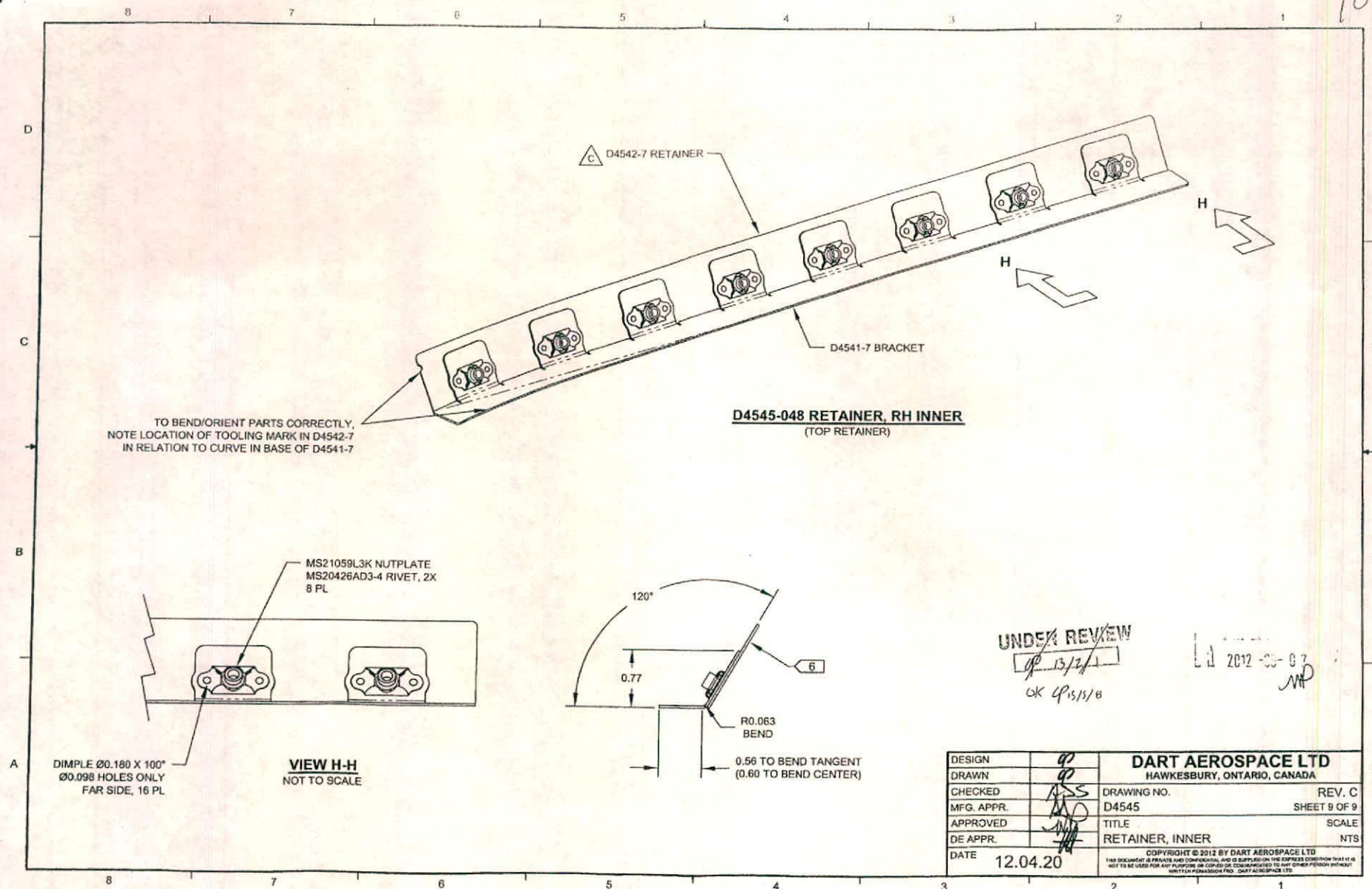
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